

Date: Tuesday, 1/16/2007 11:29:32 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206/OH-58 SADDLE, INBOARD, RIGHT SIDE - UNDER REVIEW  
 Job Number : 30282  
 Estimate Number : 10939  
 P.O. Number : N/A Part Number : D29382  
 This Issue : 1/16/2007 S.O. No. : N/A Drawing Number : D2938 UNDER REVIEW  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : B  
 Previous Run : 29348 Material : N/A  
 Due Date : 1/30/2007 Qty: 10 Um: Each  
 Written By :  
 Checked & Approved By :  
 Comment : Est: B 00.06.26 New DWG rev (mpp 2069) EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6101003 7075-T7351 2X6.25X7.875



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Issue material from stock: 7075-T7351 (QQ-A-250/12)

Cut Size 2.0" x 6.25" X 7.88" Grain Along 7.88" Length  
 (D6101-003)

Batch No: B25346 X1

B25349 X 87

B24891 X 2

mk 07/01/26 10

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Program part number and batch number.

1-Inspect part number and batch number are programmed correctly.

2-Machine Step No 1 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet

3-Machine Step No 2 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet

4-Machine Step No 3 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet

5-Deburr

mk 07/01/26

10

3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

sf 07/02/02 10

4.0 QC1 INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

mk 07/01/26

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: 11 Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: 12 Date: 07/02/13  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 1/16/2007 11:29:32 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE - UNDER  
REVIEW

Job Number: 30282

Part Number: D29382

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

BC 07-02-06

10

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

HL/YL

07-02-02 (10)

7.0

POWDER COATING

POWDER COATING



M103141



(EX) 10X

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M-R/YL

07/02/12

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

PC 7/02/12

(10)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

STY82

PC 7/02/12

(10)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/02/13

(10)

Job Completion



U 07-02-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 30282
<b>Description:</b> 206 Saddle, Outboard, Right side	<b>Part Number:</b> D2938-2
<b>Inspection Dwg:</b> D2938 Rev. B	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		0.130	0.129	0.130	0.128		
B	0.100	0.140		0.130	0.129	0.130	0.129		
C	0.100	0.140		0.120	0.118	0.121	0.118		
D	0.210	0.230		0.222	0.222	0.222	0.221		
E	1.245	1.255		1.250	1.249	1.249	1.250		
F	1.245	1.255		1.250	1.249	1.249	1.250		
G	2.495	2.505		2.500	2.499	2.499	2.499		
H	0.510	0.515							
I	1.572	1.582		1.576	1.575	1.575	1.576		
J	2.495	2.505		2.500	2.499	2.499	2.499		
K	0.257	0.262	DT8683	0.259	0.258	0.258	0.258		
L	0.312	0.317	DT8686	0.314	0.314	0.314	0.314		
M	0.235	0.240							
N	0.100	0.140		0.121	0.121	0.121	0.121		
O	0.540	0.560		0.548	0.550	0.550	0.550		
P	0.490	0.510		0.500	0.499	0.501	0.502		
Q	3.715	3.725		3.716	3.716	3.716	3.717		
R	2.720	2.760		2.738	2.738	2.741	2.740		
S	0.240	0.270		0.253	0.253	0.253	0.253		
T	0.100	0.180		0.142	0.142	0.141	0.141		
U	1.625	1.635		1.628	1.627	1.628	1.627		
V	1.362	1.372		1.366	1.366	1.364	1.366		
W	0.316	0.321	DT8690	0.319	0.319	0.319	0.319		
X	1.250	1.270		1.260	1.260	1.261	1.260		
Y	1.565	1.585		1.574	1.575	1.575	1.573		
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	ML
Date:	07/01/26

Audited by:	SG
Date:	07.02.06

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	#

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 30282
<b>Description:</b> 206 Saddle, Outboard, Right side	<b>Part Number:</b> D2938-2
<b>Inspection Dwg:</b> D2938 Rev. B	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		0.128	0.129	0.129	0.128		
B	0.100	0.140		0.127	0.130	0.129	0.128		
C	0.100	0.140		0.119	0.118	0.118	0.115		
D	0.210	0.230		0.222	0.222	0.221	0.222		
E	1.245	1.255		1.250	1.250	1.249	1.249		
F	1.245	1.255		1.250	1.250	1.250	1.249		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515							
I	1.572	1.582		1.577	1.576	1.576	1.576		
J	2.495	2.505		2.500	2.500	2.499	2.499		
K	0.257	0.262	DT8683	0.258	0.259	0.259	0.259		
L	0.312	0.317	DT8686	0.314	0.314	0.314	0.314		
M	0.235	0.240							
N	0.100	0.140		0.121	0.122	0.121	0.121		
O	0.540	0.560		0.549	0.550	0.550	0.550		
P	0.490	0.510		0.502	0.501	0.502	0.501		
Q	3.715	3.725		3.716	3.716	3.716	3.716		
R	2.720	2.760		2.741	2.741	2.741	2.741		
S	0.240	0.270		0.253	0.252	0.252	0.253		
T	0.100	0.180		0.140	0.141	0.141	0.142		
U	1.625	1.635		1.627	1.627	1.627	1.627		
V	1.362	1.372		1.366	1.366	1.366	1.366		
W	0.316	0.321	DT8690	0.319	0.319	0.319	0.319		
X	1.250	1.270		1.260	1.260	1.260	1.260		
Y	1.565	1.585		1.575	1.574	1.574	1.574		
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	<i>Full</i>
Date:	07/01/26

Audited by:	SG
Date:	07.06.06

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	

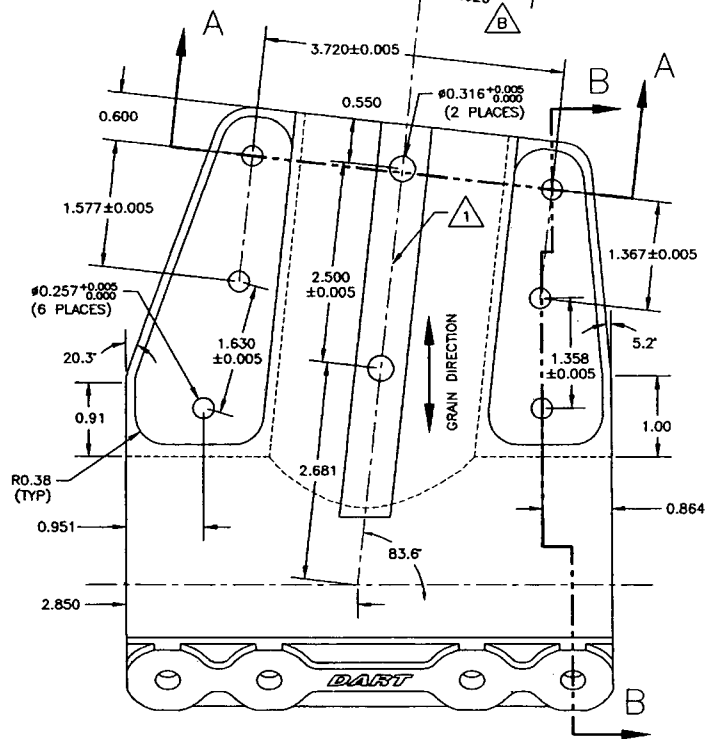
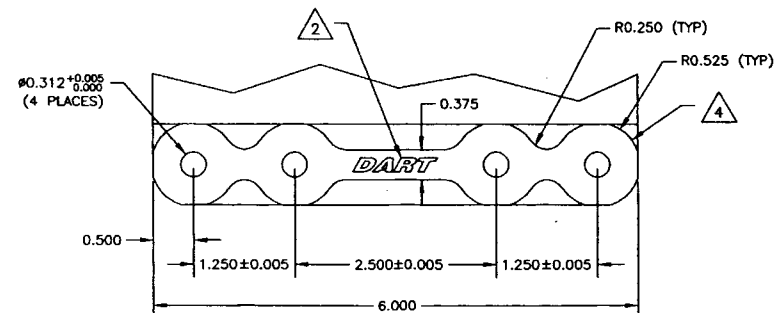
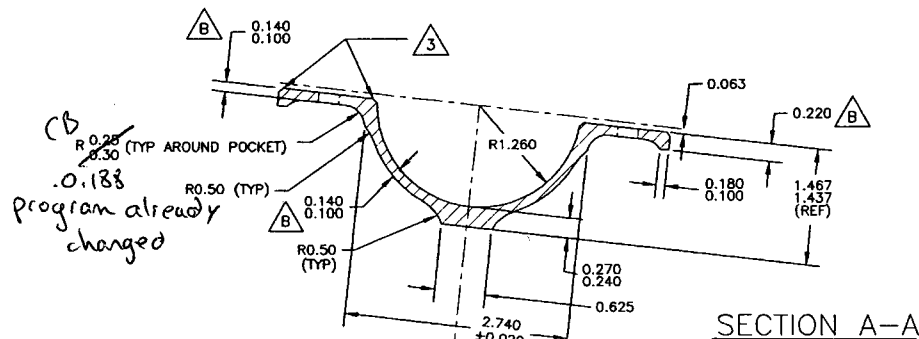
<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 30282
<b>Description:</b> 206 Saddle, Outboard, Right side	<b>Part Number:</b> D2938-2
<b>Inspection Dwg:</b> D2938 Rev. B	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. B and record below:

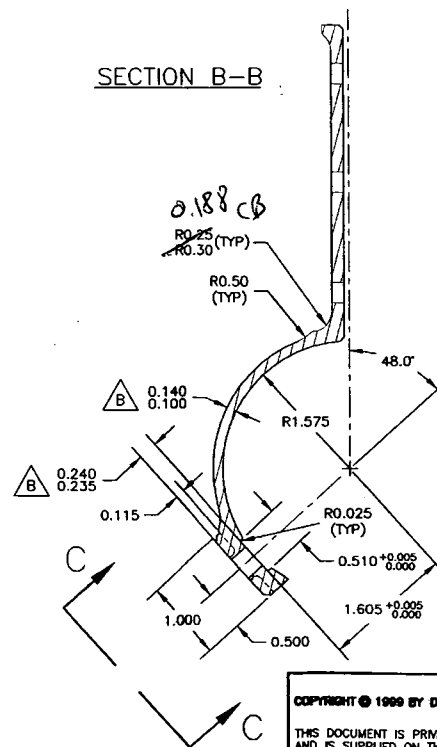
				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		0.129	0.128				
B	0.100	0.140		0.129	0.128				
C	0.100	0.140		0.117	0.117				
D	0.210	0.230		0.222	0.222				
E	1.245	1.255		1.249	1.249				
F	1.245	1.255		1.249	1.250				
G	2.495	2.505		2.500	2.500				
H	0.510	0.515							
I	1.572	1.582		1.576	1.576				
J	2.495	2.505		2.500	2.500				
K	0.257	0.262	<del>DT8683</del>	0.258	0.258				
L	0.312	0.317	<del>DT8686</del>	0.314	0.314				
M	0.235	0.240							
N	0.100	0.140		0.121	0.121				
O	0.540	0.560		0.550	0.550				
P	0.490	0.510		0.501	0.501				
Q	3.715	3.725		3.717	3.717				
R	2.720	2.760		2.740	2.740				
S	0.240	0.270		0.253	0.254				
T	0.100	0.180		0.141	0.141				
U	1.625	1.635		1.637	1.627				
V	1.362	1.372		1.366	1.366				
W	0.316	0.321	<del>DT8690</del>	0.319	0.319				
X	1.250	1.270		1.260	1.261				
Y	1.565	1.585		1.573	1.574				
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: <i>ml</i>	Audited by: <i>BC</i>
Date: 07/01/26	Date: 07.02.06

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF <i>[initials]</i>	<i>[initials]</i>



SECTION B-B



D2938-1 LH SADDLE (SHOWN)  
D2938-2 RH SADDLE (OPPOSITE)

MATERIAL: 7075-T7351 (QQ-A-250/12)  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER  
DART QSI 005 4.3  
BREAK ALL SHARP EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP
- 2 ENGRAVE DART LOGO TO MAX DEPTH OF 0.005 WITH MIN RAD 0.250
- 3 CHAMFER 0.050" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 4 CHAMFER 0.050" x 45°

RELEASED  
00-05-31

UNDER REVIEW

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 30282

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B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	DRAWN BY	<b>DART</b> DART AEROSPACE USA, INC. BELLEVUE, WA
CHECKED	APPROVED	DRAWING NO. D2938
DATE	00.05.29	TITLE SADDLE OUTSIDE
		REV. B SHEET 1 OF 1 SCALE 2:3